

Work Order ID 67372

Thursday, March 17, 2011 7:24:26 AM



Page 1

Item ID: D3339-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad Center

Start Date: 3/17/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3339

Rev **B*

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3339 1.1 Dwg Rev: *B* 1.1 Prog Rev: *B* 1.2-
Deburr if necessary

ml 11 03 17 (10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 11 03 17 (10)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/17

(40)

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RECEIVED

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Reference:

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

[illegible]

Memo

0.00

1-Deburr if necessary□2-Form as per Dwg D3339 using DT8326 and DT8261

SB 11/03/18

0.00

00000000000000000000

QC5- Inspect part completeness to step on W/O

Memo

0.00

QC

Quality Control

0.00

[illegible]

Large Fab s

Memo

0.00

Large Fab

Large Fab

1-Weld Hard coat 7560 per Dwg D3339,use DT8210 & DT8810 Layout

Jig/A/R 7560 Hardcoat Batch: M116772

Work Order ID 67372

Thursday, March 17, 2011 7:24:26 AM



Page 3

Item ID: D3339-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad Center

Start Date: 3/17/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
			S ul 03/22						
			(X10)						
170 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00 0.00							
			12:00						
			START TIME: 12:30 FINISH TIME: 3:00						
			OVEN TEMPERATURE: 300 OF						
180 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			10 BL 11-3-22						

10X M-L 11/03/22

Work Order ID 67372

Thursday, March 17, 2011 7:24:26 AM



Page 4

Item ID: D3339-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad Center

Start Date: 3/17/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>497A</i>	0.00							
	Packaging	0.00							
	Memo								
	Packaging								
200	QC21- Final Inspection - Work Order Release	0.00							
	QC	0.00							
	Memo								
	Quality Control								

10/13/22 (10)

11/3/22

C21103/22

Picklist Print

Thursday, March 17, 2011 7:24:24 AM

Page 1

Work Order ID: 67372

Parent Item: D3339-3

Parent Item Name: Wearpad Center



Start Date: 3/17/2011

Required Date: 3/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

sf

44.6250



1

11.03.17

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT

44.5

116791

44.5

MAT19

0.125

111410

0.125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

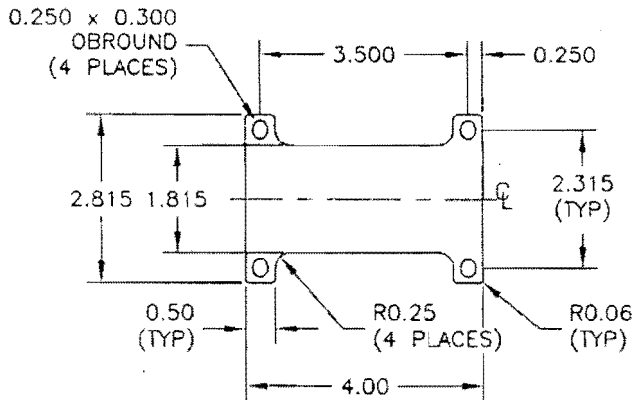
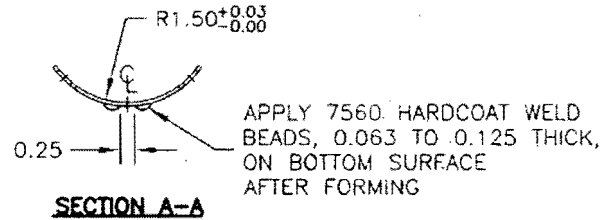
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

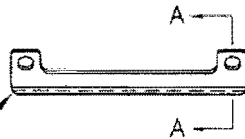
NOTE: Date & initial all entries

DART**RELEASED**
05-11-27

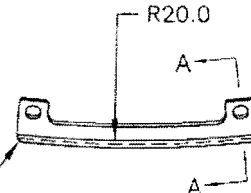
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	

**D3339-1F FLAT PATTERN****SECTION A-A**

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-3T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-3 CENTER WEARPAD**
(MADE FROM D3339-1F)

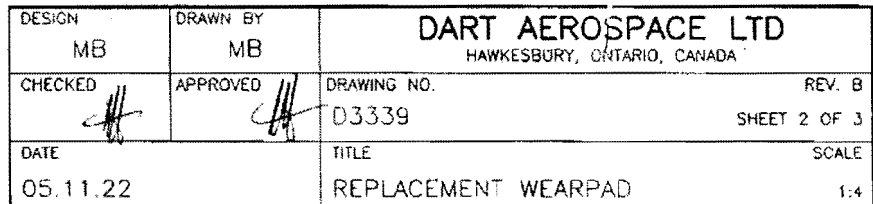
APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-5T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-5 FORWARD WEARPAD**
(MADE FROM D3339-1F)**D3339-1F/-3/-5 WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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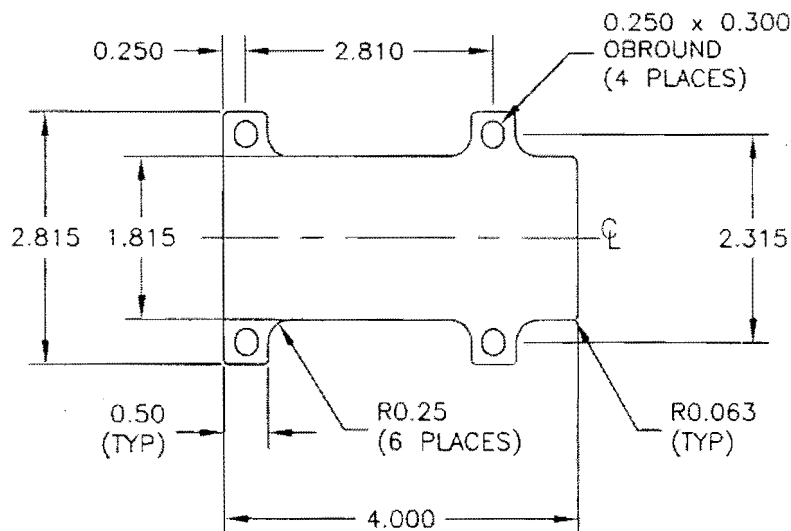


- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

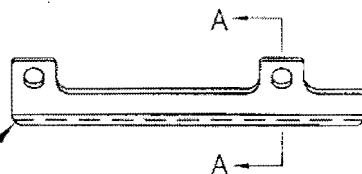
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DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:2

**D3339-9F FLAT PATTERN****RELEASED**
05.11.27 H

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-9T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-9 AFT WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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